



Dart Aerospace Ltd.
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D3914-041
Job Sheet 183327



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/16/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Large Fab-5		<i>03-10-18</i>
100	Large Fab	1 pcs	11/2/18	11/2/18	0.00	6.67	Large Fab 1		<i>03-10-18</i>
110	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC9		<i>18-10-18</i>
120	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC5		<i>18-10-18</i>
130	Powdercoat	1 pcs	11/2/18	11/2/18	0.00	0.40	Powdercoat4		<i>18-10-18</i>
135	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC3		<i>18-10-18</i>
140	HandFinish	1 pcs	11/2/18	11/2/18	0.00	0.80	HandFinish3		<i>18-10-18</i>
150	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC3		<i>18-10-18</i>
160	Packaging	1 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-2		<i>18-10-18</i>
170	QC21-SA	1 Ea	11/2/18	11/2/18	0.00	0.00	QC21		<i>18-10-18</i>

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

138839 130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

START: 2:00 *TEMP: 520°* *FINISH: 2:30*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>5097502</i>
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5112316</i>
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5113730</i>
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	<i>5110937</i>
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	<i>5110523</i>
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	<i>5113739</i>
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	<i>5064261</i>
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	<i>5111126</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

90-Start up Operation					
D2581	2	92	0		
D3914-1	2	11	0		
D3914-7	2	16	0		
D4016-3	3	22	0		
D4018-5	9	57	0		
D4020-5	1	2	0		
D4021-3	1	14	0		
D4035-043	2	14	0		
Part Specifications					
Specifications could not be found.					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Suspect ☐		AGAINST DEPARTMENT/PROCESS Demand ☐ Skid tube ☐ Cross tube ☐ Water let ☐																																																																			
				Engineering ☐ Quality ☐ Other ☐ (1042) Approval ☐ Completed By _____ and / Supervisor _____ al Verification _____ A Coordinator _____ Approval _____																																																																			
Date : _____ Step #: _____		Description Work Order Deviation		 Container No: S115550 Part: D3914 - 041 Job No: 183327 Serial No/Batch: S115550 Revision: A/D Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/03/18																																																																			
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